

Date: Wednesday, 6/6/2007 3:06:06 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER
Job Number	: 32831			
Estimate Number	: 12825			
P.O. Number	:		Part Number	: D3578041
This Issue	: 6/6/2007	S.O. No. :	Drawing Number	: D3578 REVA
Prsh Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 32483		Material	:
Written By	:		Due Date	: 6/27/2007
Checked & Approved By	:	10/07/06-07	Qty:	60 Um: Each
Comment	: Est: A 07.04.11 New issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.4410 sf(s) 6061-T6 sheet 0.080" (M6061T6S080)	
		Batch: ml 07 06 10	(60)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3578 (Run prog. D3578-1)	
		Dwg Rev: A Prog Rev: A ml 07 06 10	(60)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		ml 07 06 10	(60)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		2006-11	(60)
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			(PTO)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Open rivet holes to 0.098" and C'sink as per dwg D3578	
		5/0	07/06/07
		QC 5	56 PTO
			En 07/06/11/08 (56)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/07/18	S.O	Add QC5 for c'sink c'sink inspection. perm. change	JL	07/06/18		J 07/06/18	J 07/06/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 0106/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	S.O	C'sink hole is to big 4-part scrap	J QSI042	Scrap, destroy	07/06/18 SAD	J 07/06/18	J 07/06/18	J 07/06/18

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 32831

Part Number: D3578041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(56K)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m1 07/06/19

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-06-19

8.0 MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nutplate

Batch: m18534

9.0 MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

m1563 -

mf 07-06-19

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

rnF

07-06-19

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07-06-120

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/6/07 (56)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/01

Job Completion



07/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

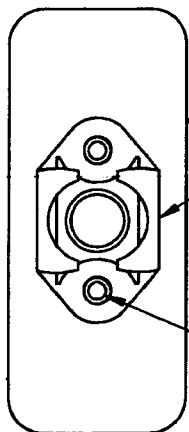
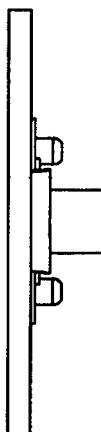
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JB</i>	APPROVED <i>MM</i>	DRAWING NO. D3578
DATE 07.01.12	TITLE DOUBLER	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)

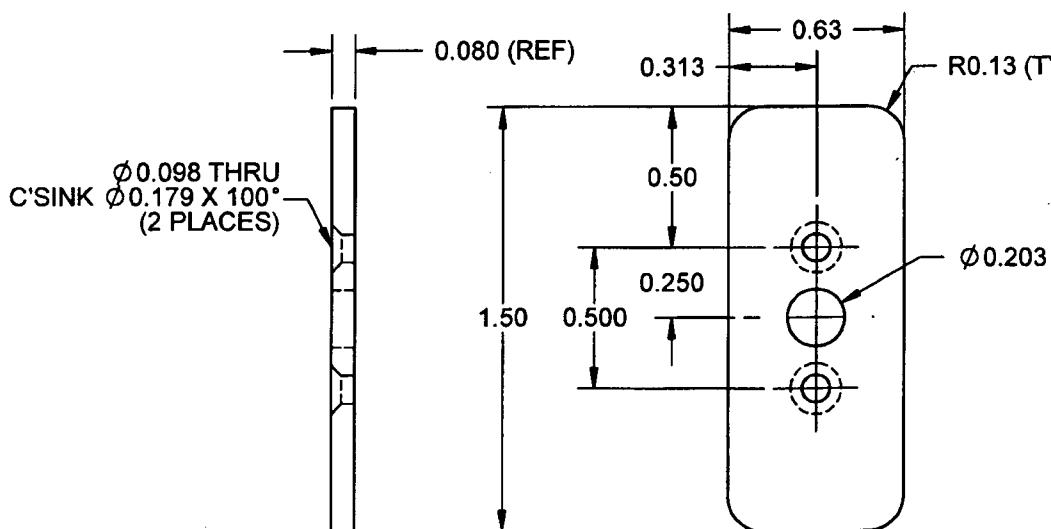
RELEASED
07.04.02 #

D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLERD3578-041 NOTES:

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3283

**D3578-1 PLATE**D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD

Work Order: 32831

Description: Doubler

Part Number: D3518-1

Inspection Dwg: D3518 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.098$	+0.004-0.001	0.098	✓		VERN	
B $\phi 0.203$	+0.005-0.001	0.203	✓		VERN	
C 0.63	+1-0.030	0.63	✓		VERN	
D 1.50	+1-0.030	1.503	✓		VERN	
E 0.500	+1-0.010	0.500	✓		VERN	
F 0.50	+1-0.030	0.504	✓		VERN	
G R0.13	+1-0.030	R0.13	✓		R-G	
H 0.250	+1-0.010	0.247	✓		VERN	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. M.
Date:	07/06/10

Audited by:	
Date:	07/06/11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	